

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021667**Date Inspected:** 11-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

CWI Inspector: NA

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

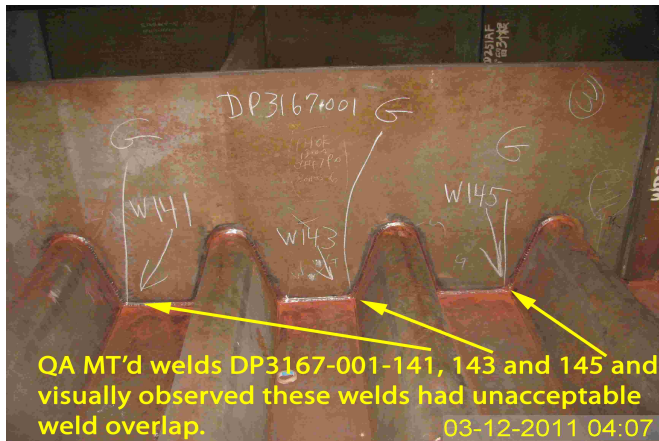
OBG Bay 14.

This QA Inspector performed random magnetic particle (MT) inspections of segment 14E deck plate welds DP3167-001-019~024, 409~417, 194, 195, 197, 198, 377, 378, 385, 386, 393, 394, 401, 415, 417, 423,210, 211, 218, 219, 226, 227, 234, 235, 248, 249, 256, 257, 264, 265, 272, 273, 291, 292, 299, 300, 307, 308, 315, 326, 334, 335, 342, 343, 350, 351, 358, 39, 207, 208, 280~289, 323~332, 366, 375, 082~093, 136~147, 199~206, 043,044, 051, 052, 059, 060, 067, 068, 075, 076, 095, 096, 103, 104, 111, 112, 119, 120, 127, 128, 149, 050, 157, 058, 169, 170, 177, 178, 189, 190, 191, 192, 042, 046, 050, 053, 058, 061, 066, 069, 074, 077, 094, 097, 102, 105, 110, 113, 118, 121, 126, 129, 148, 151, 156, 159, 164, 165, 168, 171, 176, 179, 209, 212, 217, 220, 225, 228, 233, 236, 247, 250, 255, 258, 263, 266, 271, 274, 290, 293, 298, 301, 306, 309, 314, 317, 333, 336, 341, 344, 349, 353, 357, 360, 376, 379, 384, 387, 392, 395, 400 and 403, NWIT (NDT Inspection Notification Sheet) 8519 item #4. The NWIT listed above indicates welds DP3167-001-418~422 were also presented for MT inspections. This QA Inspector observed these welds do not appear to have been completed. This QA Inspector observed welds DP3167-001-141, 143 and 145 were visually unacceptable due to weld overlap at the toe of the weld. This QA Inspector was not able

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

to locate any ZPMC workers with grinding equipment to remove the weld overlap and dayshift QA Inspectors acknowledged they would have these areas of weld overlap removed. For additional information on these inspections see this QA Inspector's TL6028 magnetic particle test report and the photographs below.



Summary of Conversations:

See Above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey +8615000026784, who represents the Office of Structural Materials for your project.

Inspected By: Dawson,Paul

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer
